












Date: Tuesday, 10/06/2008 12:54:39 PM  
 User: Julie Lecocq



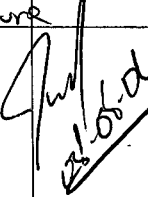
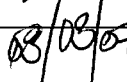
## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: INNER AFT SADDLE
Job Number	: 39796		
Estimate Number	: 11082		
P.O. Number	:	Part Number	: D5957
This Issue	: 10/06/2008 S.O. No. :	Drawing Number	: D5957 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 39621	Material	:
Written By	:	Due Date	: 30/06/2008 Qty: 12 Um: Each
Checked & Approved By	: <u>JL 008-6-10</u>		
Comment	: Est Rev:E Re-Format 05-11-29 JLM Est Rev:F ecn826 06.12.06 ec		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	Mat not in computer <sup>Saddle Billet</sup> 25 08/08/06	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) D6101-007(7075-T7351) Size 2.50" x 7.50" X 8.25" (Grain along 7.50") Batch: <u>B34875</u>			
2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3	
			
Comment: HAAS CNC VERTICAL MACHINING #3  1-Machine as per folio D5957, Ensure Batch Number is entered  2-Machine Keyway  3-Deburr & Tumble			
3.0	QC1	INSPECT ALL DIM TO DIM SHEET	
			
Comment: INSPECT ALL DIM TO DIM SHEET			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK			
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D5957 PAR #: N/A Fault Category: Prod/Machined Part NCR: Yes No DQA: D Date: 08/08/12  
 QA: N/C Closed: D Date: 08/08/12

NCR: <u>35796</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/06	2.0	Operator forgot Machine in .100" instead of .001" increment The cutter Plunged in the part. (operator Error)		Scrap and Destroy and Repl/see. Qty 4 B#34875 * Remind operator to be more cautious.	St 08/08/06	S 8/8/7		S 08/08/06
			08/08/07	Fix Program so adjustments don't have to be PAR 08-024	 08/08/06	S 8/8/7		S 08/08/06

NOTE: Date & initial all entries

Date: Tuesday, 10/06/2008 12:54:39 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER AFT SADDLE

Job Number: 39796

Part Number: D5957

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M108523



12X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:15  
320 °F  
11:45

M-L 08/08/11

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



98



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-11

12X

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 91

8/8/11

SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39796
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b> D5957
<b>Inspection Dwg:</b> D5957	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	1 1/2	2 1/2	3 1/4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.320	.320	.320	.320		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.318	322	.318	.318	.318	.318		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.500	.500	.500	.500		
N	1.865	1.885		1.876	1.875	1.875	1.875		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.260	2.260	2.260	2.260		
Q	0.307	0.312		.310	.309	.309	.309		
R	0.760	0.765		.760	.760	.760	.761		
S	0.490	0.510		.501	.510	.505	.506		
T	1.625	1.645		1.636	1.635	1.635	1.635		
U	2.000	2.020		2.002	2.003	2.003	2.003		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: RF  
Date: 08/08/06 / 08/08/07

Audited by: J.F.  
Date: 08/08/11

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 397910
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b> D5957
<b>Inspection Dwg:</b> D5957	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	4x	5x	6x	7x		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.248		
F	4.745	4.755		4.750	4.750	4.750	4.748		
G	0.315	0.322		.320	.320	.320	.322		
H	1.522	1.532		1.530	1.530	1.530	1.526		
I	3.048	3.058		3.050	3.050	3.050	3.051		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318		.318	.318	.318	.322		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.500	.500	.500	.500		
N	1.865	1.885		1.875	1.877	1.877	1.881		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.260	2.260	2.260	2.260		
Q	0.307	0.312		.309	.309	.309	.309		
R	0.760	0.765		.760	.760	.760	.762		
S	0.490	0.510		.502	.502	.503	.502		
T	1.625	1.645		1.635	1.637	1.637	1.639		
U	2.000	2.020		2.000	2.000	2.002	2.004		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: LS  
Date: 08/08/06 / 08/08/07

Audited by: J.F.  
Date: 08/08/11

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 39796
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b> D5957
<b>Inspection Dwg:</b> D5957	<b>Rev:</b> B	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	8	9	10	11	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.749	1.749	1.748		
C	5.245	5.255		5.250	5.249	5.249	5.248		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.247	5.248	5.248	5.249		
F	4.745	4.755		4.747	4.748	4.748	4.749		
G	0.315	0.322		.322	.322	.322	.322		
H	1.522	1.532		1.525	1.525	1.526	1.526		
I	3.048	3.058		3.052	3.052	3.054	3.052		
J	4.575	4.585		4.581	4.581	4.580	4.579		
K	0.313	0.318	.322	.322	.322	.322	.322		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.495	.495	.495	.496		
N	1.865	1.885		1.849	1.879	1.878	1.878		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.259	2.258	2.254	2.255		
Q	0.307	0.312		.309	.309	.309	.309		
R	0.760	0.765		.761	.761	.761	.761		
S	0.490	0.510		.502	.502	.503	.502		
T	1.625	1.645		1.637	1.637	1.636	1.637		
U	2.000	2.020		2.002	2.002	2.001	2.001		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>me</i>
Date: 08/08/07

Audited by: J.F.
Date: 08/08/11

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	

ART AEROSPACE LTD

Work Order: 39796

Description: Inner Aft Saddle

Part Number: D5957

Inspection Dwg: D5957

Rev: B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	$\times 12$	$\phi$	$\theta$	$\pi$		
A	0.438	0.443		.440					
B	1.745	1.755		1.750					
C	5.245	5.255		5.250					
D	6.995	7.005		7.000					
E	5.240	5.260		5.251					
F	4.745	4.755		4.751					
G	0.315	0.322		.322					
H	1.522	1.532		1.526					
I	3.048	3.058		3.053					
J	4.575	4.585		4.580					
K	<del>0.313</del>	<del>0.318</del>		.322					
L	0.495	0.505		.500					
M	0.490	0.510		.496					
N	1.865	1.885		1.880					
O	7.990	8.010		8.006					
P	2.240	2.260		2.255					
Q	0.307	0.312		.309					
R	0.760	0.765		.766					
S	0.490	0.510		.502					
T	1.625	1.645		1.636					
U	2.000	2.020		2.002					
V	0.023	0.043		.033					
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: *cm*

Date: 08/08/07

Audited by: J.F.

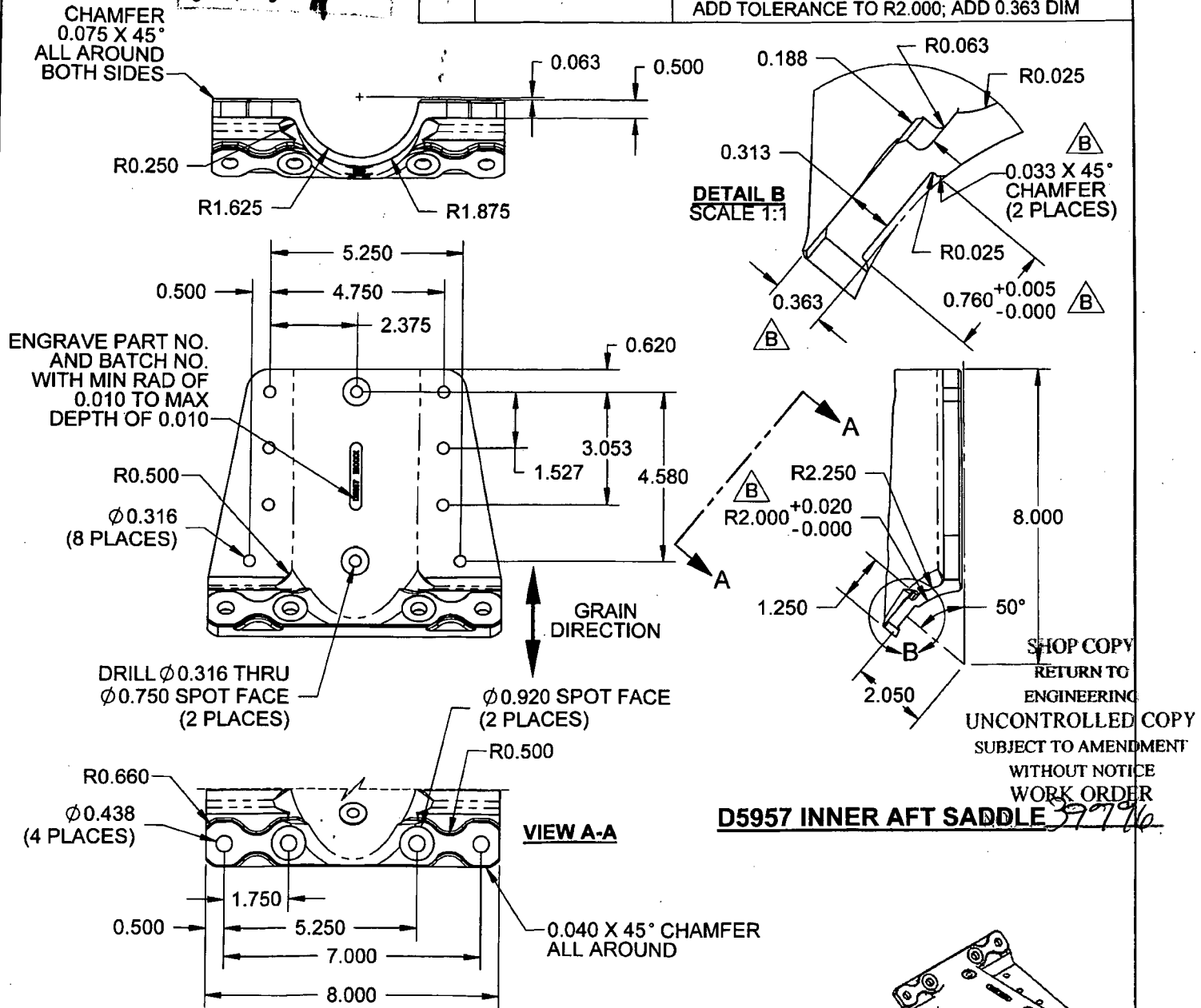
Date: 08/08/11

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	



**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D5957</b>	REV. B SHEET 1 OF 1
DATE <b>06.11.07</b>	TITLE <b>INNER AFT SADDLE</b>		SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$ ; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	



**ISOMETRIC VIEW**  
SCALE 1:8

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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